

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-05 Date Opened: 09 Jan 17 Title: FabricationAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Mounting Beams Product Model: High Quantity: 2 sets**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

| |
|-----|
| DB |
| N/A |
| DB |
| DB |
| N/A |
| gc. |
| N/A |
| N/A |

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

| |
|-----|
| gc. |
| gc. |

Drawing List

| Drawing # | Rev # | Description | Initial or N/A |
|-----------|-------|-------------|----------------|
| 76630 | 0 | Beams | DB |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | |

Traveller

Initial or N/A

| |
|--|
| |
| |
| |
| |
| |
| |
| |

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

| |
|------------|
| TTGC 2/2 |
| N/A |
| TT N/A GC. |
| N/A |

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

| |
|-----|
| gc. |
| N/A |
| gc. |
| N/A |
| gc. |

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

| |
|-----|
| N/A |
| N/A |
| N/A |

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

| |
|-----|
| JC |
| N/A |
| N/A |

Work performed by:

Print: D. BartfaiSign: [Signature]SCA: AD07Date: 09 JAN 17

ICC / Dual Inspection performed by:

Print: T. ClarkeSign: [Signature]SCA: AD02Date: 12 JAN 17

Work Order closed by:

Print: T. ClarkeSign: [Signature]SCA: AD02Date: 06 Dec 17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 High mount Fwd beam No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 76630-01 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-05

Remaining Tasks to be Performed: Assemble beams with pins &
part number, Fix powder chip & fc.

Signature: Jff Cel.

Date: 25 Jan 2017 Lic. No. / SCA AD02

In Process

| | | | | | | |
|--|--------------------|---|---------|--|---|-----------------------------------|
| 1. Approving Civil Aviation Authority/Country Transport Canada | | 2. AUTHORIZED RELEASE CERTIFICATE FORM ONE | | | 3. Form Tracking No. 2017-0455 | |
| 4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3 | | | | | 5. Work Order/Contract/Invoice WO 2017-05 | |
| 6. Item | 7. Description | 8. Part Number | 9. Qty. | 10. Serial/Batch No. | 11. Status/Work | |
| 1. | Forward Beam Ass'y | 76630-01 | 1 | N/A | New | |
| 2. | Aft Beam Ass'y | 76630-02 | 1 | | | |
| 12. Remarks | | | | | | |
| 13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12. | | | | 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. | | |
| 13b. Signature  | | 13c. Approved Organization Number AMF 73-04 | | 14b. Signature | | 14c. Approved Organization Number |
| 13d. Name Jeff Clarke - AD02 | | 13e. Date (dd/mmm/yyyy) 04 Dec 2017 | | 14d. Name | | 14e. Date (dd/mmm/yyyy) |
| <p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p> | | | | | | |

ELBOW RIVER HELICOPTERS

WO# 2017-05

Rev. Original 27 May 2013



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 High mount A7 beam No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 76630-02 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-05

Remaining Tasks to be Performed: Assemble beams with pins
& part number ✓ JC.

Signature: [Signature]

Date: Jan 25th/2017 Lic. No. / SCA AD-07

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

04 DEC 2017



Description: Beam Pin

WO# 2017-05

[illegible]

04 DEC 2017



WO# 2017-05

[illegible]

| | | | | | |
|---|--|---|--|---|---|
| 1. Approving Civil Aviation Authority/Country Transport Canada | | 2. AUTHORIZED RELEASE CERTIFICATE FORM ONE | | | 3. Form Tracking No. 2017-045 |
| 4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3 | | | | 5. Work Order/Contract/Invoice WO 2017-05 | |
| 6. Item 1. 2. | 7. Description Forward Beam Ass'y Aft Beam Ass'y | 8. Part Number 76630-01 76630-02 | 9. Qty. 1 1 | 10. Serial/Batch No. N/A | 11. Status/Work New |
| 12. Remarks | | | | | |
| 13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12. | | | 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. | | |
| 13b. Signature  | | 13c. Approved Organization Number AMF 73-04 | | 14b. Signature | |
| 13d. Name Jason Rekve - AD01 | | 13e. Date (dd/mmm/yyyy) 19 January 2017 | | 14c. Approved Organization Number | |
| | | | | 14d. Name | |
| | | | | 14e. Date (dd/mmm/yyyy) | |
| <p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p> | | | | | |



Description: Beam Pin

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



WO# _____

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

[illegible]

Work Order: 2017-05Material Tracking Sheet
Bell 206L/407 HIGH Forward Mounting Beams

1 of 2

Date Opened: 9 Jan 2017

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|------------|-----|----------------|-------------|-----------------------|--|---------|
| | 2 | | 76630-01 | Forward Beam Assembly | | |
| Step 1 | | | | Fabrication | | |
| | | | 73 | | 304 Stainless, 1x2x0.125 tube | 15073 |
| Step 2 | | | | Machining | None | |
| Step 3 | | | | Fabrication | | |
| | 2 | | 49222-07 | Bushing | 316 Stainless, 5/8" rod | 16002 |
| | 2 | | 49222-08 | Bushing | 316 Stainless, 5/8" x 0.120 tube | 15025 |
| | 1 | | 69830-16 | Strap | 304 Stainless, 0.105" Sheet | 15046 |
| | 2 | | 69830-17 | Block | 304 Stainless, 3/16" x 3/4" bar | 2016-77 |
| | 1 | | 76630-10 | Cap | 321 Stainless, 0.032" Sheet | 3021 |
| | 1 | | 69830-20 | Cap | 321 Stainless, 0.032" Sheet | 3021 |
| | 2 | | 76630-13 | Guide | 304 Stainless, 3/4" x 0.065" Rnd. Tube | 15073 |
| | 2 | | 76630-15 | Pin | 304 Stainless, 5/16" Rod | 15073 |
| Step 4 | | | | Welding | | |
| | A/R | | -- | Welding Rod | ER308L | 14028 |
| Step 6 | | | | Straightening | None | |
| Step 7 | | | | Inspection | None | |
| Step 8 | | | | Powder Coating | | 17007 |

Work Order: 2017-05Material Tracking Sheet
Bell 206L/407 HIGH Forward Mounting Beams

2 of 2

Date Opened: Jan 2017

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|------------|-----|----------------|----------------|-----------------------|-------------------------------|---------------|
| Step 9 | | | | <i>Final Assembly</i> | | |
| a. b. | | | -21 | Stop | 6061-T6 Aluminum, 5/8" Rod | See PDS |
| | .1 | | 69830-22 | Knob | 6061-T6 Aluminum, 3/4" Rod | See PDS |
| | 1 | | 23 | Coil Spring | 15mm x 70 mm Spring | See PDS |
| | | | | | | See PDS |
| | .1 | | MS21044C3 | Nut | | See PDS |
| | | | | | 6061-T6 Aluminum, 0.75" Rod | 10036 See PDS |
| | .1 | | 69830-1032X2.5 | #10-32 x 2.5 Screw | Stainless Steel, Commercial | See PDS |
| | .1 | | NAS1149C0363R | Washer | | See PDS |
| | .1 | | MS21044C3 | Nut | | See PDS |
| | | | | | 17 Tape, 1/2", black on white | Commercial |

MOUNTING BEAM FABRICATION – 76630

General

These instructions apply to mounting beams 76630-01 (forward) and 76630-02 (aft) for Bell 206L/407 high mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

76630, Revision 0 – Beams

Work Order: 2017-05

Batch Quantity: 2 Fwd

Date Open: 09 Jan 2017

Complete
(initial or SCA #)

| | | | |
|--------------|--------------|--------------|--------------|
| <u>2 AFT</u> | | | |
| Fwd | Fwd | Aft | Aft |
| AD | AD | AD | AD |
| <u>73-04</u> | <u>73-04</u> | <u>73-04</u> | <u>73-04</u> |
| 01 | 01 | 01 | 01 |

1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 76630-01: 76630-03 (long tube)
 - 76630-02: 49222-04 (inboard tube), 49222-05 (corner tube), 76630-06 (outboard tube)
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining

- Run CNC programs to machine keyways, slots and holes in component parts.
- De-burr keyways, slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

| | | | |
|-------------|-------------|-------------|-------------|
| <u>AD02</u> | <u>AD02</u> | <u>AD02</u> | <u>AD02</u> |
|-------------|-------------|-------------|-------------|

3. Beam Fabrication – Components

Note: Check stock before making components.

- Shear and bend caps: 76630-10, 69830-19, 69830-20, 69831-20.
- Cut and turn 49222-07 and 49222-08 bushings and 76630-13 guide tubes:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - 49222-07 only: Drill F through at 300 RPM
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut and turn 76630-14 Stops:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - Drill #9 through at 300 RPM. Countersink 90° to fit #10 screw.
 - De-burr outside with a file at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut 76630-15 pin.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list.

| | | | |
|-------------|--------------|--------------|--------------|
| AD | AD | AD | AD |
| <u>73-0</u> | <u>73-04</u> | <u>73-04</u> | <u>73-04</u> |
| 01 | 01 | 01 | 01 |

MOUNTING BEAM FABRICATION – 76630

Fwd AD 73-04 05 Fwd AD 73-04 05 Aft AD 73-04 05 Complete AD 73-04 05
 (initial or SCA #)

4. Beam Welding – 76630-01

- a. TIG weld 76630-13 guide tubes into 76630-03 tubes using ER308L rod, two places per tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 49222-07 bushings into 76630-03 tubes using ER308L rod, two places per tube, both sides.
- c. TIG weld 76630-15 pins into 76630-03 tubes using ER308L rod, two places per tube, both sides.
- d. TIG weld 49222-08 bushings into 76630-03 tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- e. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing.
 - ii. 69830-07 stops over outboard keyways.
 - iii. 69830-20, 76630-10 caps.
- f. Record component and welding rod POs / WOs on attached material list.
- g. Tag in-progress parts for finishing.

AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05

5. Beam Welding – 76630-02

- a. TIG weld 76630-13 guide tubes into 76630-06 tubes using ER308L rod, two places per tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 49222-07 bushings into 76630-06 tubes using ER308L rod, two places per tube, both sides.
- c. TIG weld 76630-15 pins into 76630-06 tubes using ER308L rod, two places per tube, both sides.
- d. TIG weld 49222-08 bushings into 76630-04 tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- e. TIG weld 76630-04, 76630-05, 76630-06 tubes using ER308L rod. Clamp tubes to a rigid fixture to maintain the tubes parallel and straight.
- f. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing.
 - ii. 69830-07 stops over outboard keyways.
 - iii. 69830-20, 76630-10 caps.
- g. Record component and welding rod POs / WOs on attached material list.
- h. Tag in-progress parts for finishing.

AD 73-04 01 AD 73-04 01 AD 73-04 01 AD 73-04 01

6. Beam Finishing

Note: straightening the beams is critical for ease of installation of the cargo basket.

- a. Straighten beams at strap using hydraulic press.
 - i. Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - ii. Use a block to distribute press loads, about 2" wide
 - iii. Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - iv. Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- b. Straighten beams into plane if required.
- c. Break sharp edges off strap and stops using sanding disc on die-grinder.
- d. Tag in-progress parts for inspection.

MOUNTING BEAM FABRICATION – 76630

7. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 76630-01 and 76630-02 for conformity to drawing.
- Tag in-progress parts ready for powder coating.

8. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

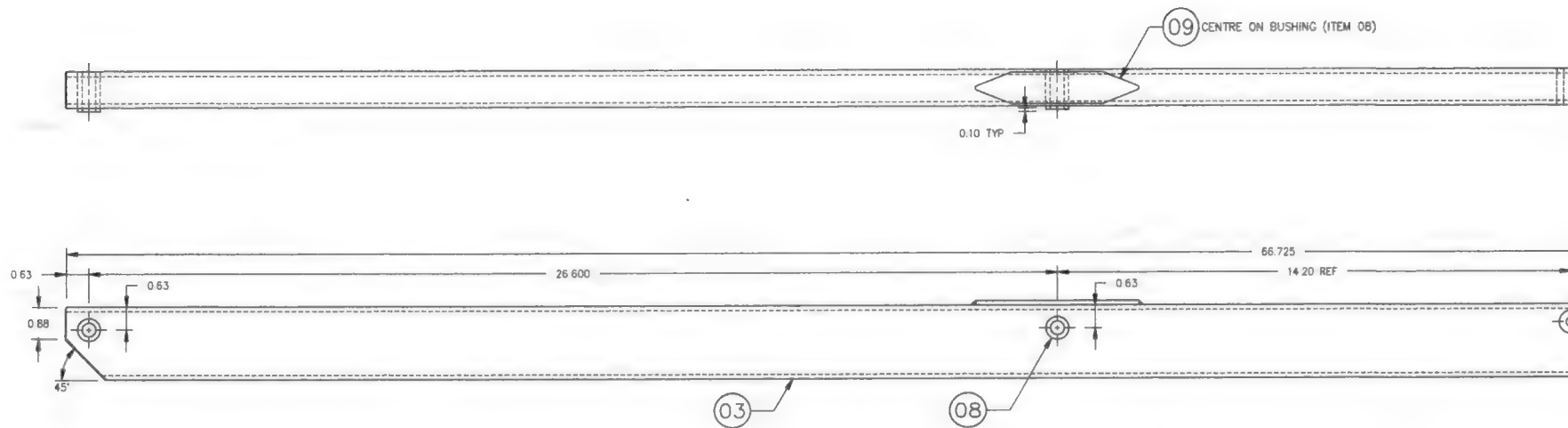
9. Final Assembly

To be completed after powder coating.

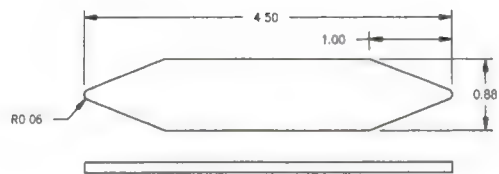
- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into outboard guide with 69830-22 knob and MS21044C3 nut. Check for function.
- Install #10-32 x 2.5" countersunk screw and 76630-14 stop into inboard guide with NAS1149C0363R washer and MS21044C3 nut.
- Adhere P/N placard to top surface of beam, between strap and end on top surface.
- Green tag completed beam assemblies and place into stock.

| | Fwd | Fwd | Complete (initial or SCA #) |
|--|-------|-------|--------------------------------|
| | AD | AD | AD |
| | 73-04 | 73-04 | 73-04 |
| | 02 | 02 | 02 |
| | AD | AD | AD |
| | 73-04 | 73-04 | 73-04 |
| | 01 | 01 | 01 |
| | AD | AD | AD |
| | 73-04 | 73-04 | 73-04 |
| | 02 | 01 | 02 |

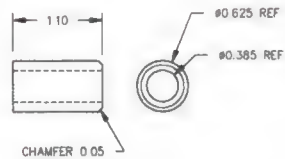
| | | | |
|---|-----------|-----------------------------|----------|
| APPROVALS | | DATE | |
| DESIGNER | ERT CLARK | 06 | SEP 2007 |
| CHECKED | | E. BLUMEN | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON | | | |
| DIMINALS | | FRACTIONS | |
| 4.000 | 0.000 | 1/16" | |
| 4.000 | 0.000 | 1/32" | |
| 4.000 | 0.000 | 1/64" | |
| 4.000 | 0.000 | 1/128" | |
| 4.000 | 0.000 | 1/256" | |
| 4.000 | 0.000 | 1/512" | |
| 4.000 | 0.000 | 1/1024" | |
| 4.000 | 0.000 | 1/2048" | |
| 4.000 | 0.000 | 1/4096" | |
| 4.000 | 0.000 | 1/8192" | |
| 4.000 | 0.000 | 1/16384" | |
| 4.000 | 0.000 | 1/32768" | |
| 4.000 | 0.000 | 1/65536" | |
| 4.000 | 0.000 | 1/131072" | |
| 4.000 | 0.000 | 1/262144" | |
| 4.000 | 0.000 | 1/524288" | |
| 4.000 | 0.000 | 1/1048576" | |
| 4.000 | 0.000 | 1/2097152" | |
| 4.000 | 0.000 | 1/4194304" | |
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| 4.000 | | | |



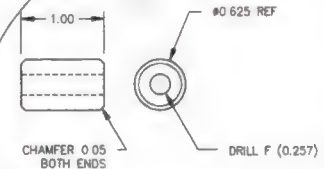
01 FORWARD BEAM ASSEMBLY



09 STRAP
SCALE 1 : 1



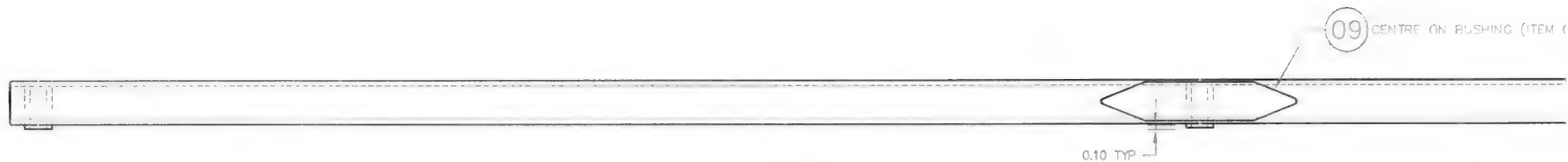
08 BUSHING
SCALE 1 : 1



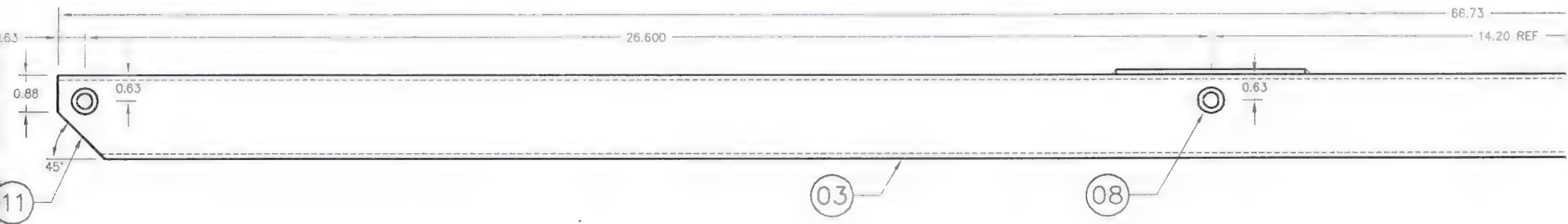
07 BUSHING
SCALE 1 : 1

49222

② AFT BEAM ASSE



FWD

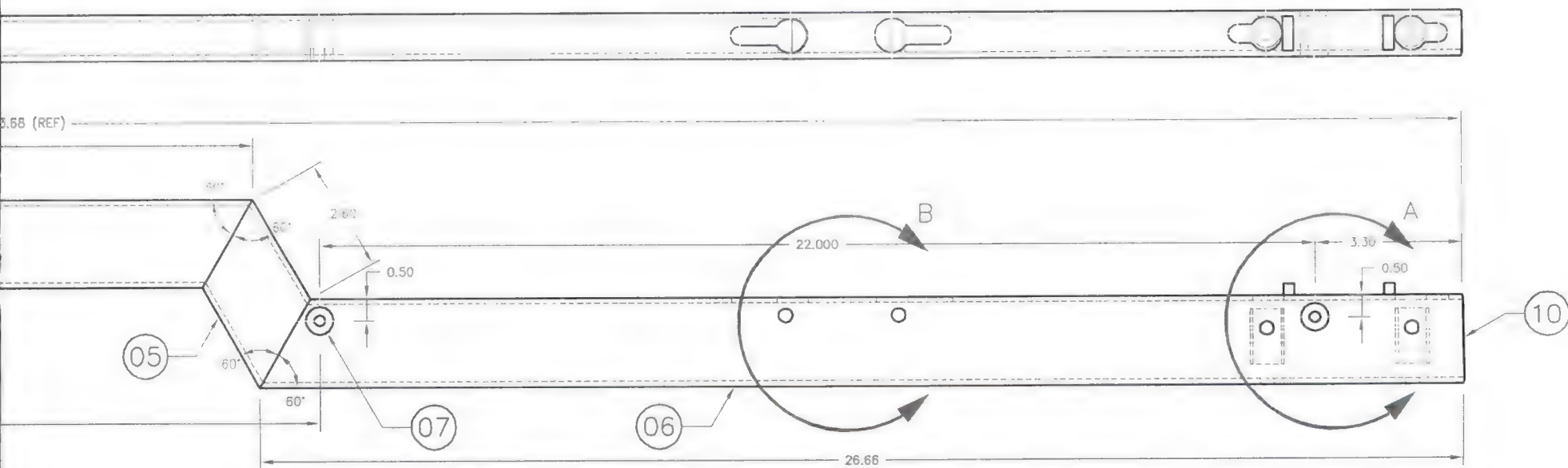


① FORWARD BEAM AS

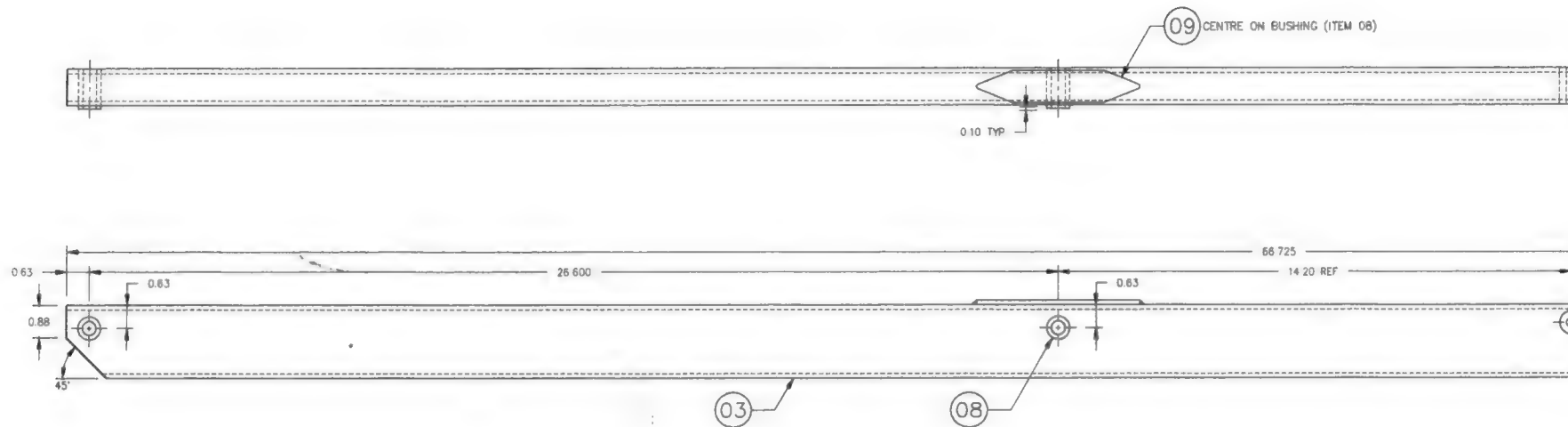
← n RR →

AET

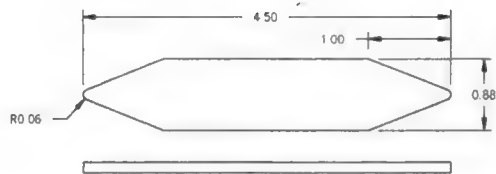
SCALE 1 : 1
FINAL ASSEMBLY AFTER POWDER COATING



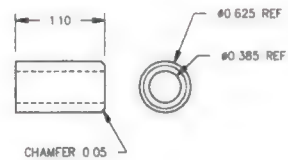
ASSEMBLY



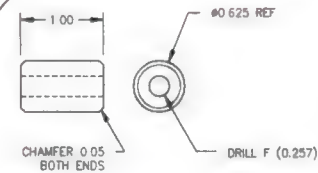
01 FORWARD BEAM ASSEMBLY



09 STRAP
SCALE 1 : 1



08 BUSHING
SCALE 1 : 1

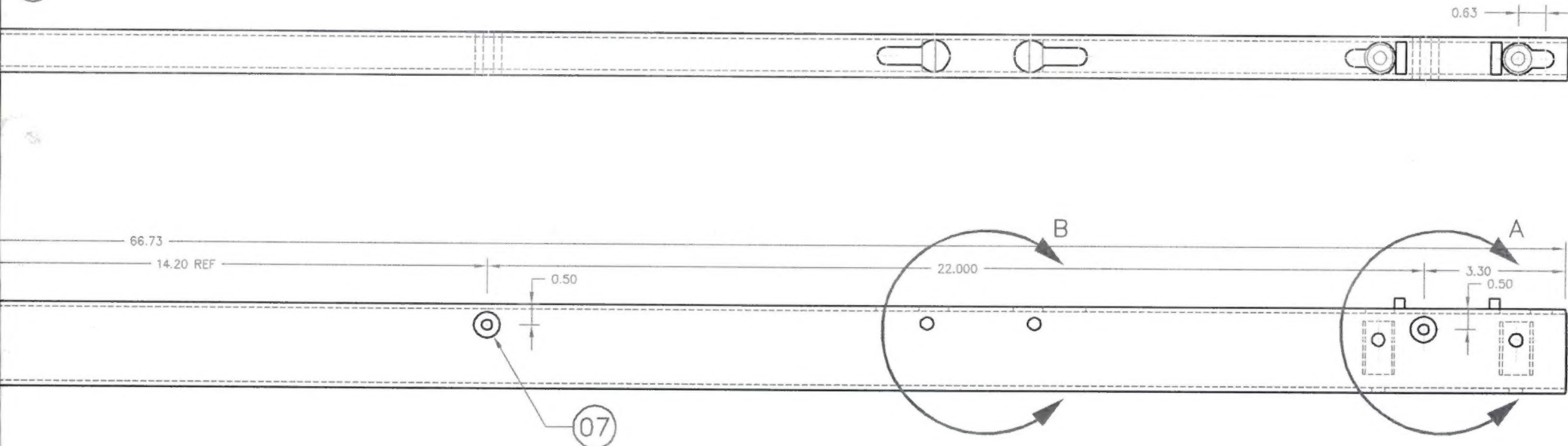


07 BUSHING
SCALE 1 : 1

49222

02 AFT BEAM ASSEMBLY

09 CENTRE ON BUSHING (ITEM 08)



FORWARD BEAM ASSEMBLY

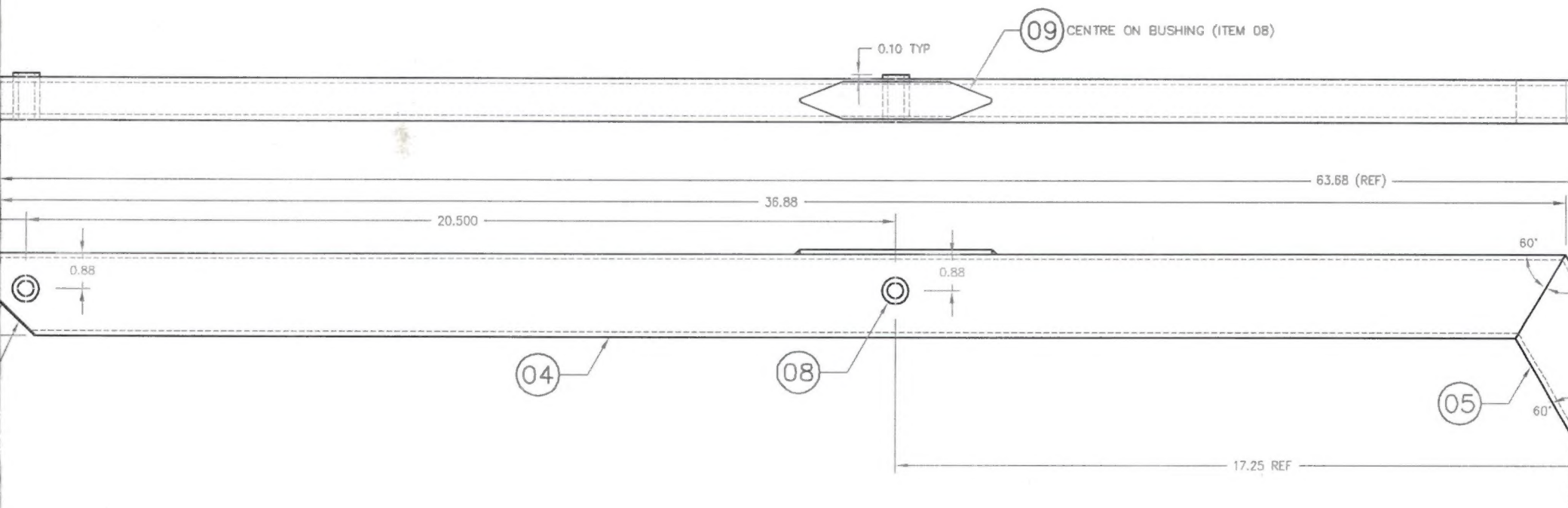
| | | | | | | |
|---|---|--------------|--------------|-----------------|------------|--|
| 2 | 2 | MS21044C3 | NUT | | | |
| 1 | 1 | AN960C10 | WASHER | | | |
| 1 | 1 | #10-32 X 2.5 | C'SUNK SCREW | STAINLESS STEEL | COMMERCIAL | |

NOTES

1. REMOVE

SCALE 1 : 1

SCALE 1 : 1
PRIOR TO ASSEMBLY OF STOP COMPONENTS



(02) AFT BEAM ASSEMBLY

09 CENTRE ON BUSHING (ITEM 08)

Work Order: 2017-05Material Tracking Sheet
Bell 206L / 407 HIGH Aft Mounting Beams

1 of 2

Date Open: 9 Jan 2017

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|---------------|----------|----------------|-----------------|--------------------------|--|----------------|
| | <u>2</u> | | 69831-02 | Aft Beam Assembly | | |
| Step 1 | | | | <i>Fabrication</i> | | |
| | . 1 | | 49222-04 | Tube | 304 Stainless, 1x2x0.125 tube | <u>15073</u> |
| | . 1 | | 49222-05 | Tube | 304 Stainless, 1x2x0.125 tube | <u>15073</u> |
| | . 1 | | 76630-06 | Tube | 304 Stainless, 1x2x0.125 tube | <u>15073</u> |
| Step 2 | | | | <i>Machining</i> | <i>None</i> | |
| Step 3 | | | | <i>Fabrication</i> | | |
| | . 2 | | 49222-07 | Bushing | 316 Stainless, 5/8" rod | <u>16002</u> |
| | . 2 | | 49222-08 | Bushing | 316 Stainless, 5/8" x 0.120 tube | <u>15025</u> |
| | . 1 | | 69830-06 | Strap | 304 Stainless, 0.105" Sheet | <u>15046</u> |
| | . 2 | | 69830-07 | Block | 304 Stainless, 3/16" x 3/4" bar | <u>2016-77</u> |
| | . 1 | | 76630-10 | Cap | 321 Stainless, 0.032" Sheet | <u>3021</u> |
| | . 1 | | 69831-20 | Cap | 321 Stainless, 0.032" Sheet | <u>3021</u> |
| | . 2 | | 76630-13 | Guide | 304 Stainless, 3/4" x 0.065" Rnd. Tube | <u>15073</u> |
| | . 2 | | 76630-15 | Pin | 304 Stainless, 5/16" Rod | <u>15073</u> |
| Step 5 | | | | <i>Welding</i> | | |
| | . A/R | | -- | Welding Rod | ER308L | <u>14028</u> |
| Step 6 | | | | <i>Straightening</i> | <i>None</i> | |
| Step 7 | | | | <i>Inspection</i> | <i>None</i> | |
| Step 8 | | | | <i>Powder Coating</i> | | <u>17007</u> |

Work Order: 2017-05Material Tracking Sheet
Bell 206L / 407 HIGH Aft Mounting Beams

2 of 2

Date Open: Jan 2017

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|---------------|-----|----------------|----------------|-----------------------|-------------------------------|---------|
| Step 9 | | | | <i>Final Assembly</i> | | |
| Step 9.b. | . 1 | | 69830-21 | Stop | 6061-T6 Aluminum, 5/8" Rod | See PDS |
| | . 1 | | 69830-22 | Knob | 6061-T6 Aluminum, 3/4" Rod | See PDS |
| | . 1 | | 69830-23 | Spring | 15mm x 70 mm Spring | See PDS |
| | . 1 | | 69830-1032X3 | #10-32 x 3 Screw | Stainless Steel, Commercial | See PDS |
| | . 1 | | MS21044C3 | Nut | | |
| Step 9.c. | . 1 | | 76630-14 | Stop | 6061-T6 Aluminum, 0.75" Rod | See PDS |
| | . 1 | | 69830-1032X2.5 | #10-32 x 2.5 Screw | Stainless Steel, Commercial | See PDS |
| | . 1 | | NAS1149C0363R | Washer | | See PDS |
| | . 1 | | MS21044C3 | Nut | | See PDS |
| Step 9.d. | . 1 | | -- | P/N Placard | TZ Tape, 1/2", black on white | See PDS |